

Work Order ID 102548

May-30-13 1:49:36 PM

102548

Page 1

Item ID: D3957-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Assembly, Door LH Lower

Stop

NS2

Start Date: 5/30/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLD

Date: 13-05-30

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3957 A

100 Pick Kit 0.00

100

Packaging

Memo

0.00

Packaging

110

110

Small Fab

Memo

0.00

Small Fab

1-Install Helicoil in d3957-3

5/30/07

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

27
13
B67

(76)

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
Bending	Bend			
Centre Not Concentric	BOM/Route			
Cracks	Broken/Damage/Defect			
Crimp/Kink/Ripple/Wave	Burrs			
Cuffs	Contamination			
Crushing	Countersink			
Heat Treat	Cut Too Short			
Inspection Strip in Tube	Drawing			
Marks/Chatter	Drill Holes			
Turning Sequence	Finish			
Wave/Twist in Tube	Fit/Function			

Work Order ID 102548

May-30-13 1:49:36 PM

102548

Page 2

Item ID: D3957-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Assembly, Door LH Lower

Stop

NS2

Start Date: 5/30/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 81679

0.00

130

Packaging

Packaging

Memo

0.00

JK

SP
B-67

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 13-06-02

ME
13-6-7

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Other <input type="checkbox"/>					
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Picklist Print

May-30-13 1:49:42 PM

Page 1

Work Order ID: 102548

102548
D3957-043

Parent Item: D3957-043

Parent Item Name: Hinge Assembly. Door LH Lower

Start Date: 5/30/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3518-3		Manufactured	No			100	Each	6.0000	1	1		FF 13-06-07
D3518-3												
Stainless Steel Ball Joint Rod End												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST054	6	
	6	

MS124818		Purchased	No	73938	100	Each	12.0000	1	1			
MS124818												
Helicoil												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST331	12	
	12	

D3957-3		Manufactured	No	112503	100	Each	2.0000	1	1			
D3957-3												
Hinge, Door LH Lower												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST064	2	
	2	

NAS509-6		Purchased	No	95525	100	Each	9.0000	1	1			
NAS509-6												
Nut												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST276	9	
	9	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

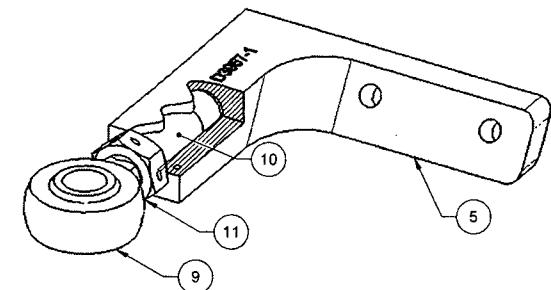
Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

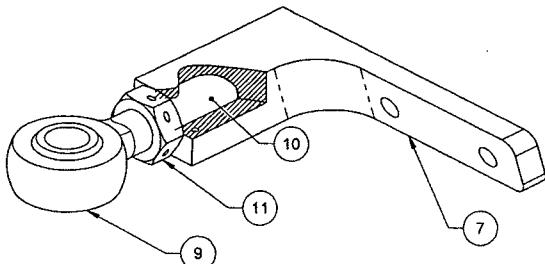
FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions	Pressure/Forced
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Crushing	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>		
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>			

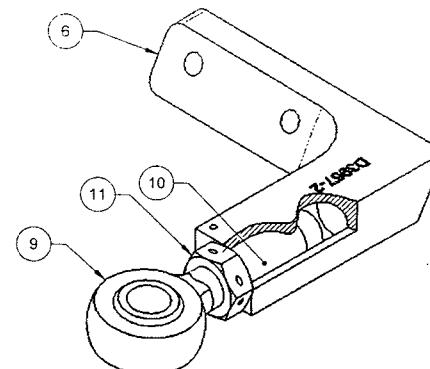
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6	1				D3957-2	HINGE, DOOR RH UPPER
7		1			D3957-3	HINGE, DOOR LH LOWER
8			1		D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



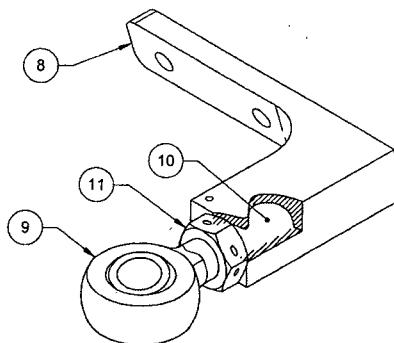
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

SHOP FOR Y
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 102548 MLJ
 130530

RELEASED
 R 2009-10-03
 JM

A NEW ISSUE		09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	REV. A
APPROVED	<i>AB</i>	D3957
DE APPR.	<i>AB</i>	SHEET 1 OF 5
DATE	09.09.03	SCALE
		INTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

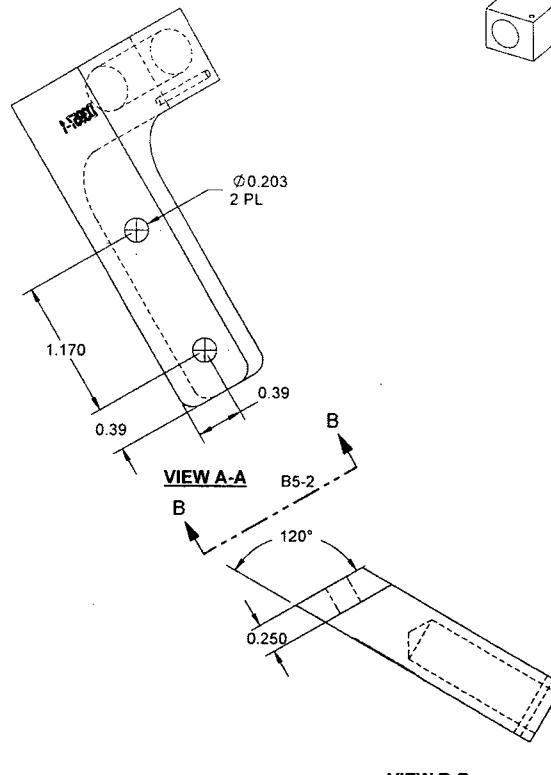
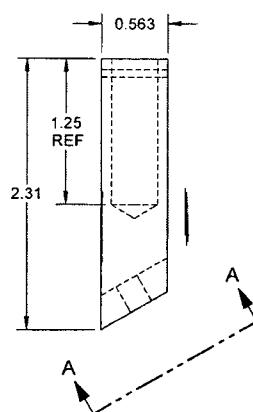
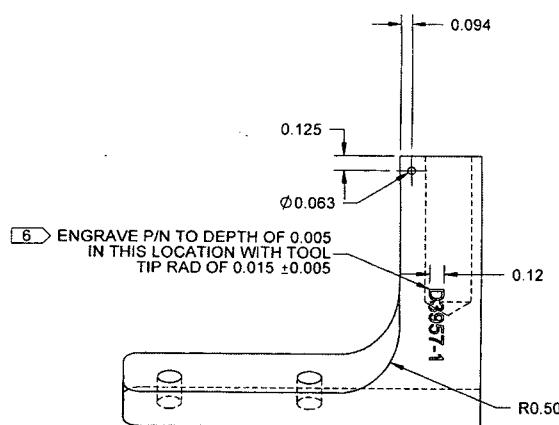
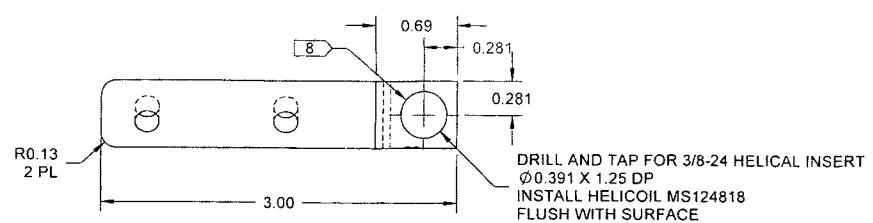
Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	
Other			



NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PIN AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

D3957-1 HINGE, DOOR LH UPPER

C3-2 **RELEASED**
R 2009-10-08

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3957	
APPROVED	<i>[Signature]</i>	REV. A	
DE APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
DATE	09.09.03	TITLE	SCALE
		HINGE	NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

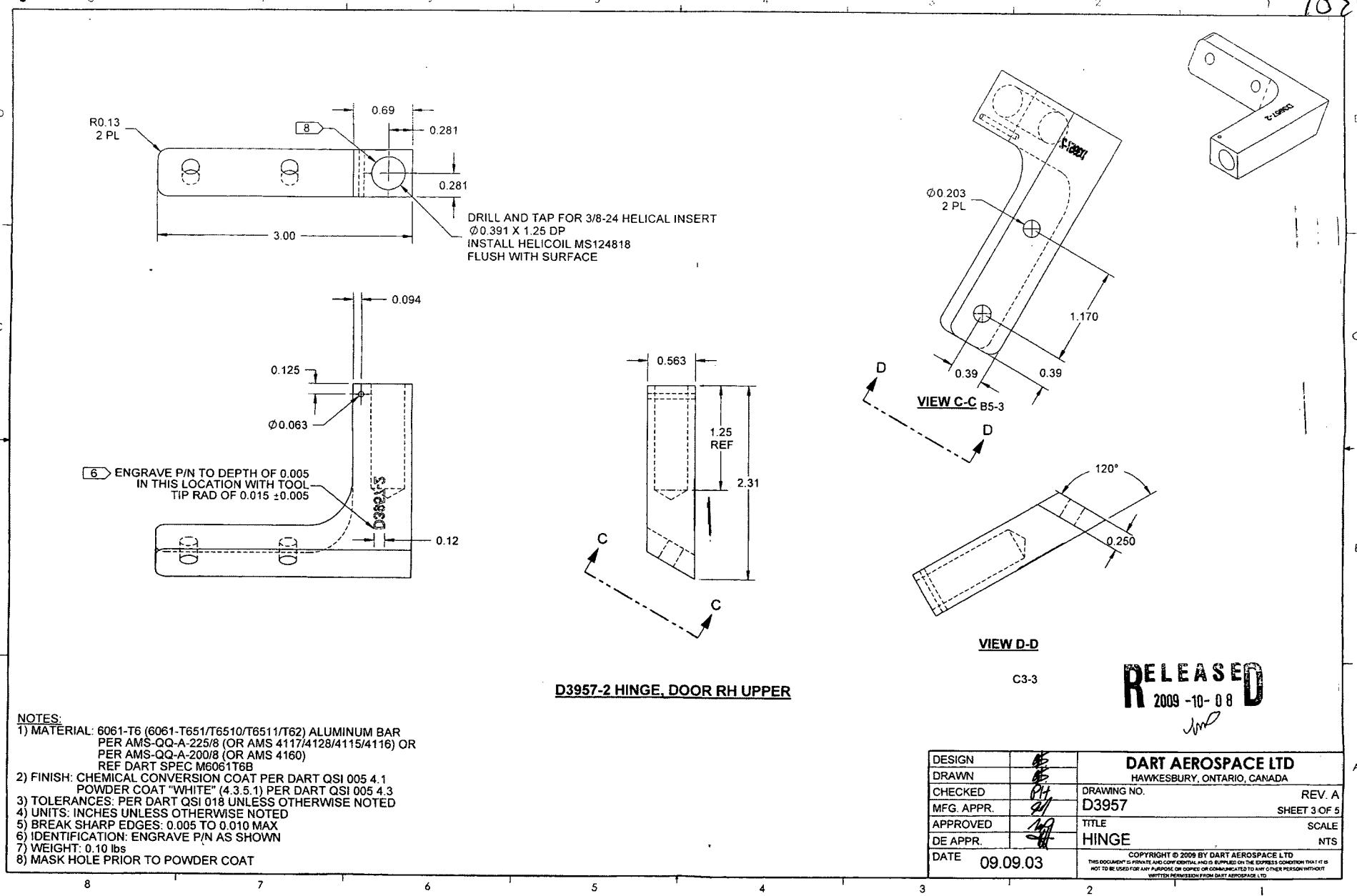
Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		



DESIGN	<i>5</i>	DART AEROSPACE LTD
DRAWN	<i>5</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>5</i>	DRAWING NO.
MFG. APPR.	<i>5</i>	D3957
APPROVED	<i>5</i>	REV. A
DE APPR.	<i>5</i>	SHEET 3 OF 5
DATE	09.09.03	SCALE
		NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

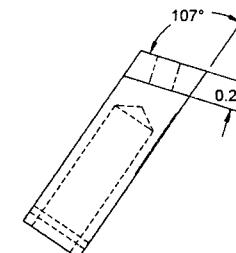
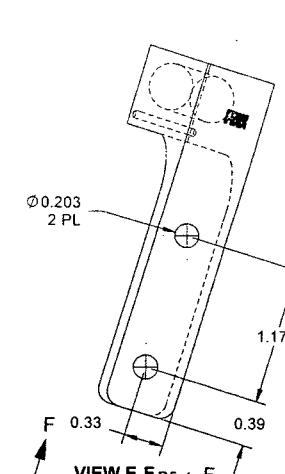
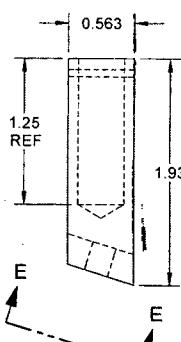
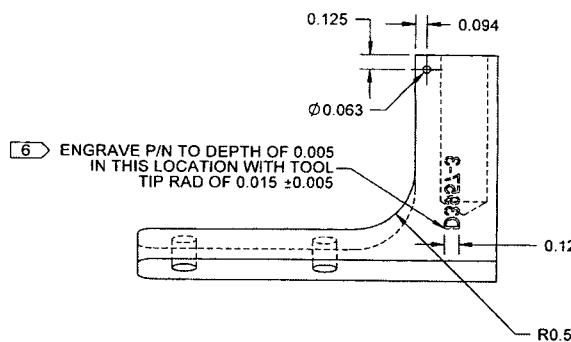
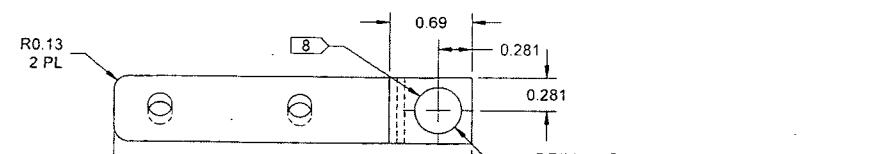
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
	Bending	Bend	Folio/Program						
	Centre Not Concentric	BOM/Route	Grain						
	Cracks	Broken/Damage/Defect	Hardware						
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified						
	Cuffs	Contamination	Instructions Incomplete/Unclear						
	Crushing	Countersink	Misaligned/off center						
	Heat Treat	Cut Too Short	Mislabeled						
	Inspection Strip in Tube	Drawing	Misread						
	Marks/Chatter	Drill Holes	Off-set						
	Turning Sequence	Finish	Out of Calibration						
	Wave/Twist in Tube	Fit/Function	Out of Sequence						



VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
2009-10-08
MAP

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	
MFG. APPR.	<i>AB</i>	D3957	
APPROVED	<i>AB</i>	REV. A	
DE APPR.	<i>AB</i>	SHEET 4 OF 5	
DATE	09.09.03	TITLE	HINGE
		SCALE	NTS

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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

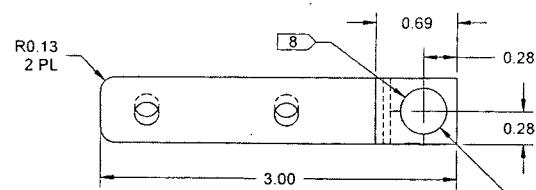
Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

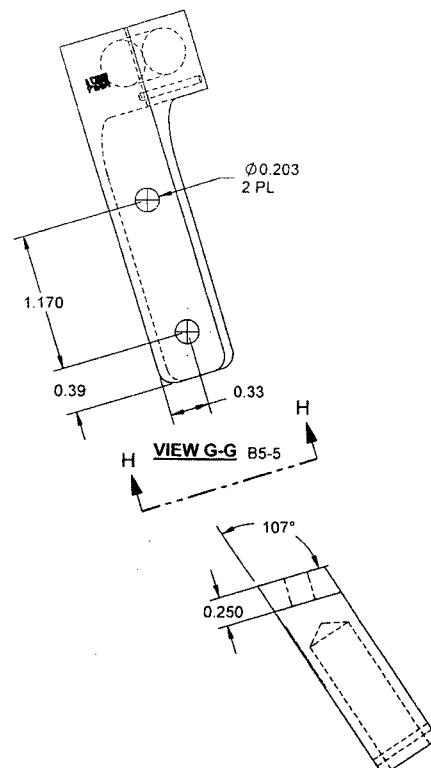
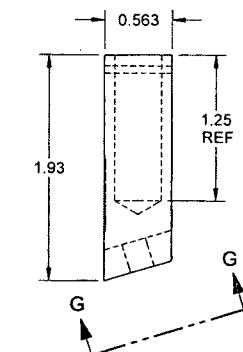
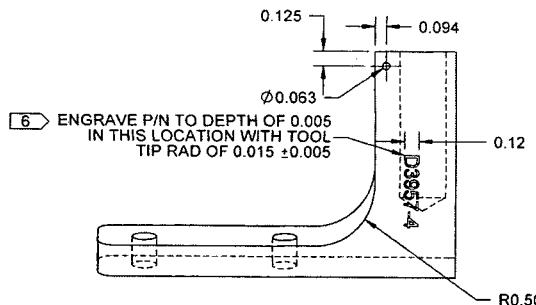
FAULT CATEGORY

Landing Gear		General															
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other												

162548



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW H-H C3-5

D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>BB</i>	DART AEROSPACE LTD
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	DRAWING NO.
MFG. APPR.	<i>BB</i>	REV. A
APPROVED	<i>BB</i>	D3957
DE APPR.	<i>BB</i>	SHEET 5 OF 5
DATE	09.09.03	NTS

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RELEASED
 2009-10-08
BB

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced			
Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up			
Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure			
Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld			
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled			
Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other			
Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>				
Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>				
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>				
Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>				



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 1-613-632-3336 Fax: 1-
613-632-4443
sales@darths.com

PURCHASE ORDER

Purchase Order ID **PO6288**

Purchase Order Date 5/30/2013
PO Print Date 5/30/2013

Page Number 1 of 1

Order From :	VU-DAR001	Ship To :	HELICOPTERES PANORAMA LTEE(CHPAN01)
DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CAN		360 CHEMIN DE L'AEROPORT ALMA, QC G8B 5V2 CANADA	

Contact Name	SHANNON HADLEY		
Vendor Phone	613 632 5200	Buyer	WARRANTY PAR13-232
Ship To Contact	DONALD MANUEL	Customer POID	
Ship To Phone	418 668 3046	Customer Tax #	
Ship Via:	FedEx Overnight	Terms	Net 30
Ship Acct:	1517-9324-0 DAS	Currency	USD
		FOB	Origin

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
			Promise Date						
1	D3957-043	HINGE ASSEMBLY, DOOR LR LOWER 102548	5/30/2013 5/30/2013	1.00 No	Each	\$558.00	100.00%	\$0.00	\$0.00
****UNDRILLED****									
Line Total: \$0.00									
2	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER 102549	5/30/2013 5/30/2013	1.00 No	Each	\$570.00	100.00%	\$0.00	\$0.00
****UNDRILLED****									

102550

Line Total: \$0.00

102551

PO Total: \$0.00

102552

PO Instructions: T2-K PAR13-232 ATTENTION: DONALD MANUEL
Custom part without holes, see engineering for authorization. Ship asap.

102553

102554

Note: Pricing listed above is as per contract agreement between DART Helicopter Services and the respective manufacturer.
DUTIES & TAXES TO BE BILLED TO RECEIVER.

Change Nbr: 3

Change Date: 5/30/2013